

Date: Thursday, 2/14/2008 10:56:33 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 37423	Part Number	: D29332		
Estimate Number	: 10834	Drawing Number	: D2933 REV C		
P.O. Number	:	Project Number	: N/A		
This Issue	: 2/14/2008	Type	MACHINED PARTS	Drawing Revision	: C
Prsht Rev.	: NC	Material	:	Due Date	: 3/8/2008 Qty: 6 Um: Each
First Issue	: / /				
Previous Run	: 36031				
Written By	:				
Checked & Approved By	:				
Comment	: Est: B 06-06-26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B34872	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

WO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number: 37423		Part Number: D29332
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		→ 08/03/24
6.0	HAND FINISHING	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		BR 08-03-25
7.0	POWDER COATING	POWDER COATING  M106005
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		m-f 08/03/25
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		08-03-26 x6
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 4d8A		8326 SP(6X)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		08/03/27
Job Completion		 mf
		08-03-27
		V

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	37423
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.129	.130	.130	.130		
B	0.100	0.140		.129	.128	.130	.127		
C	0.100	0.140		.125	.124	.124	.124		
D	0.210	0.230		.223	.223	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.235	.235	.235	.235		
N	0.100	0.140		.119	.114	.116	.116		
O	0.540	0.560		.541	.549	.551	.554		
P	0.490	0.510		.499	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.495	2.500	2.496		
S	0.240	0.270		.261	.261	.260	.260		
T	0.100	0.180		.142	.142	.142	.142		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.130	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.570	1.570	1.570	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<u>81</u>	Audited by:	<u>SA</u>
Date:	<u>08/03/18</u>	Date:	<u>08/03/24</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <u>JK</u>	<u>JK</u>

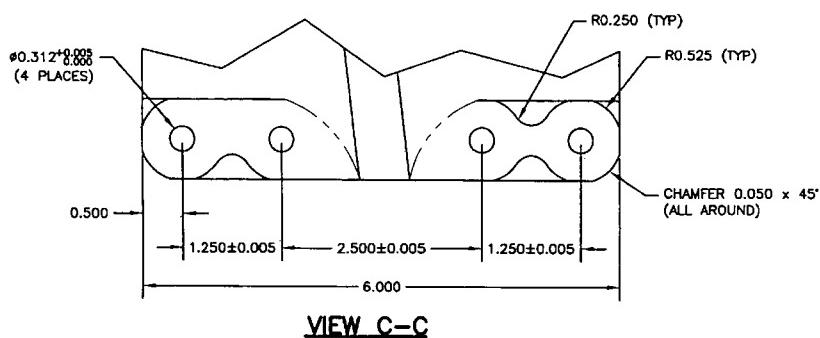
DART AEROSPACE LTD				Work Order:	37423
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.126	.125			
B	0.100	0.140		.125	.126				
C	0.100	0.140		.125	.125				
D	0.210	0.230		.219	.219				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.578	1.578				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.235	.235				
N	0.100	0.140		.118	.118				
O	0.540	0.560		.545	.550				
P	0.490	0.510		.505	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.495	2.497				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.321	.321				
X	1.125	1.145		1.130	1.130				
Y	1.565	1.585	DT8695 A/B	1.570	1.570				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SP	Audited by:	SP
Date:	08/03/19	Date:	08/03/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SP

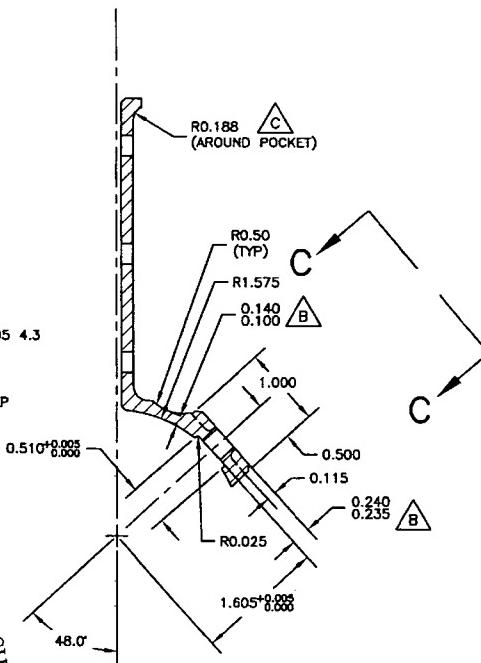


VIEW C-C

D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

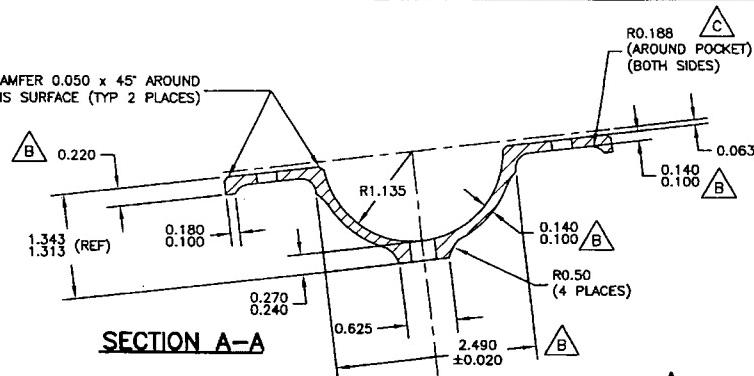
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



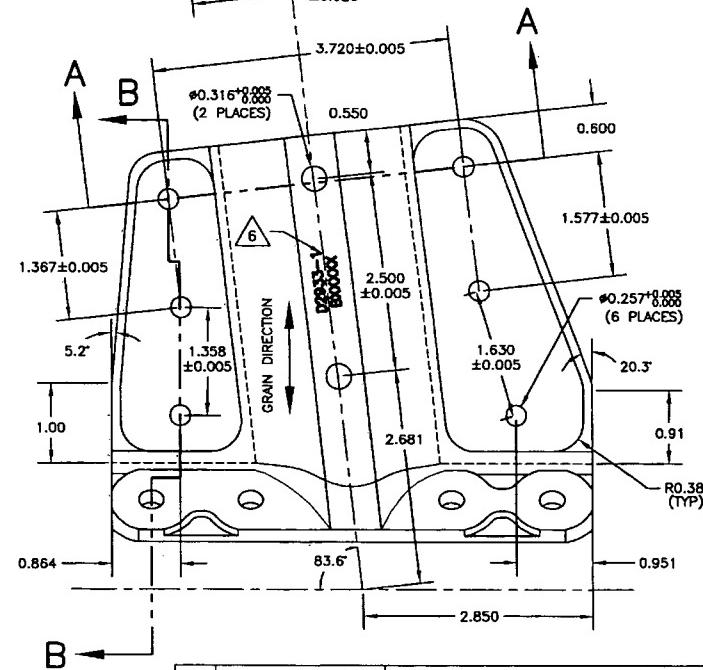
SECTION B-B

RELEASED  
 07.02.12  
 NO. 37223  
 WORK ORDER  
 ENGINEERING  
 RETURN TO  
 SHOP COPY  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

CHAMFER 0.050 x 45° AROUND  
 THIS SURFACE (TYP 2 PLACES)



SECTION A-A



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 DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	R0.188 WAS R0.30 TO R0.25
PH	CB	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
CHECKED	APPROVED	
PH	H	DART AEROSPACE USA, INC. BELLEVUE, WA
DRAWING NO.	D2933	REV. C
DATE	06.11.09	SHEET 1 OF 1
TITLE	SADDLE INSIDE	SCALE
		2:3